

# Work Order ID 118354

June-20-14 7:53:50 AM

**\*118354\***

Page 1

Item ID: D4879-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206A/B AFT Leg Assembly, LH  
 Start Date: 6/20/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/20/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: rework to Rev. B

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4879	A								

110

0.00

**\*110\***

Small Fab

Small Fab

Memo

0.00

PULL FROM KIT D206-811-011 B116555:  
 1 X D4879-041 B116564  
 REWORK TO REV.B

ALIGN PILOT HOLES IN D4879-1 WITH PILOT HOLES IN D4885-5 AND  
 D4885-7. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER  
 DWG.  
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP  
 DT9968 AS PER DWG.

1 FF 14-06-24

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Quality Control

Memo

0.00

SKP  
 4/6/25

1

# Work Order ID 118354

**\*118354\***

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Item ID: D4879-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: 206A/B AFT Leg Assembly, LH  
 Start Date: 6/20/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
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 Reference: rework to Rev. B

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9968 A/R HYSOL BATCH: <u>H128703</u>								14/06/24
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
145									
146									
147									
150	Identify as per dwg & Stock Location: <u>230</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								

145  
146  
147  
w  
Purchasing - send to P+L for assly part marking 1x SP 14-8-18.  
Purchasing - receive + Inspect for transit damage  
QC6 → 14-08-13

AUG 19 2014

DAS  
06  
9-89

DAS  
9  
9-89

DAS  
9  
9-89

Work Order ID 118354

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\*118354\*

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Item ID: D4879-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: 206A/B AFT Leg Assembly, LH

Start Date: 6/20/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/20/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference: rework to Rev. B

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

ML5 14-08-19

44-8-19

# Picklist Print

June-20-14 7:53:49 AM

Page 1

Work Order ID: 118354

**\*118354\***

Parent Item: D4879-041

**\*D4879-041\***

Parent Item Name: 206A/B AFT Leg Assembly, LH

Start Date: 6/20/14

Required Date: 6/20/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4879-041

Manufactured No

Each 0.0000

1

**\*D4879-041\***

**\*\***

116564

YMF

206A/B AFT Leg Assembly, LH

14-8-2

HL 20 PB-5-12 : m 128923

(2x)

FF

14-06-24

HL 86-5 : m 128228

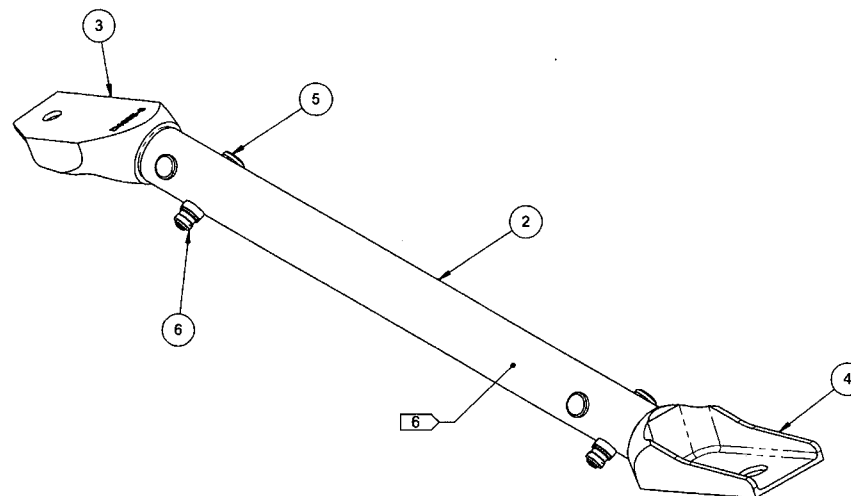
(2x)

FF

14-06-24

~~HySol EA934 NA : M128703~~

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4879-041	AFT LEG ASSEMBLY, LH
2	1	D4879-1	STRUT
3	1	D4885-5	END FITTING
4	1	D4885-7	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



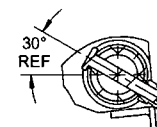
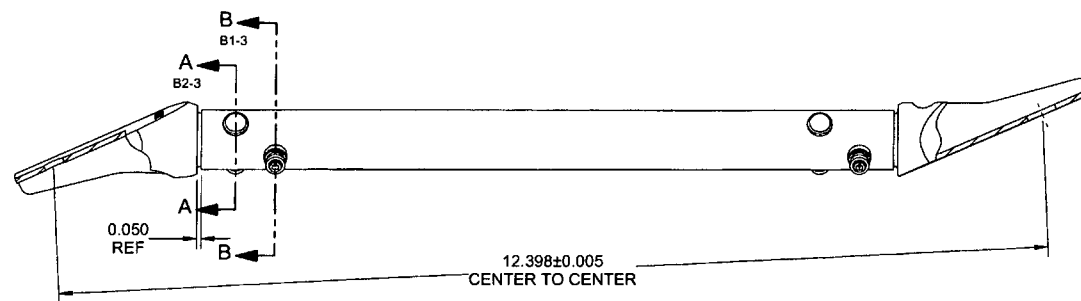
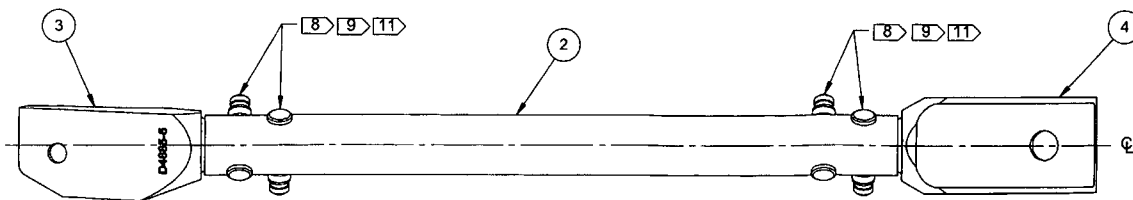
**D4879-041 AFT LEG ASSEMBLY, LH**  
(EQUIVALENT TO BELL P/N 206-062-103-001)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.77 lbs
- 8) ALIGN PILOT HOLES IN D4879-1 WITH PILOT HOLES IN D4885-5 & D4885-7.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9968
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9968
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

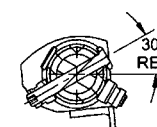
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B3-2, B1-4, B3-4)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4879</b>	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
DATE	14.04.08	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED



**SECTION A-A**  
2 PL C7-3

△ B



**SECTION B-B**  
2 PL C7-3

△ B

**D4879-041 AFT LEG ASSEMBLY, LH**  
AUXILIARY VIEW

**RELEASED**  
2014-06-16

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. <b>D4879</b>	REV. B
MFG. APPR.	JFS		SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO25267

Purchase Order Date 7/31/2014

PO Print Date 8/1/2014

Page Number 2 of 5

Order From :  
P & L PRINTING  
19226 AIRPORT ROAD  
SUMMERSTOWN, ONTARIO KOC 2E0  
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name  
Vendor Phone 613-931-1241

Ship To Contact  
Ship To Phone  
Ship Via:  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Line Total: \$3.00

4 121382

D4879-041 AFT LEG  
ASSEMBLY

8/7/2014

1.00 ✓

\$3.00

\$3.00

Yes

8/7/2014

LASER MARKED

SP148-18

Line Total: \$3.00

5 121585

D4879-042 AFT LEG  
ASSEMBLY

8/7/2014

1.00

\$3.00

\$3.00

Yes

8/7/2014

LASER MARKED

Line Total: \$3.00

6 118355

D4879-042 AFT LEG  
ASSEMBLY

8/7/2014

1.00

\$3.00

\$3.00

Yes

8/7/2014

LASER MARKED

Note:

8/1/2014



19226 Airport Road  
Summerstown, ON  
K0C 2E0 Canada

Tel. 613-931-1241  
Fax 613-931-2560  
plprinting@bellnet.ca

# Invoice

Number: 7242

Date: August 12, 2014

**Bill To:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

**Ship To:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
25267		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4801-041	2.00	3.00	✓	6.00
Laser Metal Marking, D4878-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4928-041	2.00	3.00	✓	6.00
Laser Metal Marking, D4928-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4835-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4837-041 ✓	2.00 ✓	3.00	✓	6.00 ✓
Laser Metal Marking, D4801-042	2.00	3.00	✓	6.00
Sub-Total				\$52.00
13.00% on 52.00				6.76
Total				\$58.76

Whatever we make, we make it the best we possibly can.  
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS  
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You





19226 Airport Road  
Summerstown, ON  
K0C 2E0 Canada

Tel. 613-931-1241  
Fax 613-931-2560  
plprinting@bellnet.ca

# PACKING SLIP

**SOLD TO**

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**SHIPPED TO**

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**DATE** Aug. 12, 2014

**P.O NUMBER** PO25267

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4801-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4878-042 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4928-041 LEG ASSEMBLY	2	
D4928-042 LEG ASSEMBLY	1	
D4835-041 LEG ASSEMBLY	1	
D4937-041 LEG ASSEMBLY	2	
D4801-042 LEG ASSEMBLY	2	

SP 14-8-18